**SYMPOXY™ 1010-CA810** is a two-component, room temperature curing epoxy system with a convenient 1:1 mix ratio by volume. This is a 100% solids epoxy system with a medium/low viscosity that is excellent for coating surfaces.

**Electrical potting and encapsulating, industrial surface coating, wood surface coat and seal coat. This product is excellent where a high gloss finish, lower viscosity, and good water or chemical resistance is required.**

### PRODUCT DESCRIPTION

**SYMPOXY™ 1010-CA810**

<table>
<thead>
<tr>
<th>Handling Properties</th>
<th>Test Method</th>
<th>A/B Mixed</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mix Ratio by volume A:B</td>
<td>Calculation</td>
<td>100:100</td>
</tr>
<tr>
<td>by weight A:B</td>
<td></td>
<td>100:83</td>
</tr>
<tr>
<td>Gel Time 100 grams @ 25°C</td>
<td>ASTM D-2971</td>
<td>45 min. ±5</td>
</tr>
<tr>
<td>Color (cured)</td>
<td>Visual</td>
<td>Light Amber</td>
</tr>
<tr>
<td>Shore Hardness</td>
<td>ASTM D-2240</td>
<td>75D ±5</td>
</tr>
<tr>
<td>Viscosity mixed @ 25°C</td>
<td>ASTM D-4878</td>
<td>1,500</td>
</tr>
<tr>
<td>Specific Gravity mixed @ 25°C</td>
<td>ASTM D-4669</td>
<td>1.05</td>
</tr>
<tr>
<td>Shrinkage inch/inch</td>
<td>ASTM D-2566</td>
<td>.0008</td>
</tr>
<tr>
<td>See shrinkage paragraph</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Demold Time 1/8” thick @ 25°C</td>
<td>HAPCO TEST</td>
<td>24-48 hrs.</td>
</tr>
<tr>
<td>Cubic Inches per Pound</td>
<td>Calculation</td>
<td>26.3</td>
</tr>
</tbody>
</table>

### PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Physical Properties</th>
<th>Test Method</th>
<th>Post Cured Properties*</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength (ksi)</td>
<td>ASTM D-638</td>
<td>7.2</td>
</tr>
<tr>
<td>Compressive Strength (ksi)</td>
<td>ASTM D-695</td>
<td>15.4</td>
</tr>
<tr>
<td>Izod Impact (ftlbs/in.) notched</td>
<td>ASTM D-256</td>
<td>0.85</td>
</tr>
<tr>
<td>Dielectric Strength (volt/mil)</td>
<td>ASTM D-149</td>
<td>500</td>
</tr>
<tr>
<td>Dielectric Constant - to 10⁶ fps</td>
<td>ASTM D-150</td>
<td>4.37</td>
</tr>
<tr>
<td>Volume Resistivity (ohm-cm)</td>
<td>ASTM D-270</td>
<td>3.0 x 10¹⁵</td>
</tr>
<tr>
<td>Insulation Resistance (ohms) @ 25°C</td>
<td>ASTM D-257</td>
<td>3.0 x 10¹⁵ 6.0 x 10¹⁰ 2.8 x 10⁸</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### PACKAGING

<table>
<thead>
<tr>
<th>Packaging</th>
<th>Weight</th>
<th>Cubic In. (approx.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>GALLON UNIT</td>
<td>16.5 lbs.</td>
<td>434</td>
</tr>
<tr>
<td>5 GAL. UNIT</td>
<td>82.5 lbs.</td>
<td>2,170</td>
</tr>
</tbody>
</table>

*Note: These results are based on test specimens cured 1-3 hours at room temperature then 16 hours at 175°F(80°C) The above technical data is true and accurate at the date of issuance but is subject to change without prior notice.

**Important:** The information presented here is based on carefully conducted laboratory tests and is believed to be accurate. However, results cannot be guaranteed and it is suggested that customers confirm results under their conditions and in their applications before production use. Hapco Inc. makes no warranty, whether expressed or implied, including warranties of merchantability or of fitness for a particular purpose. Under no circumstances shall Hapco Inc. be liable for incidental, consequential, or other damages from alleged negligence, breach of warranty, strict liability, tort contract, or any other legal theory, arising out of the use of handling of this product. The sole remedy of purchaser and sole liability of Hapco Inc. shall be for the purchase price of the product which is the subject of the claim.
# Material Handling & Safety Notes

## Surface Preparation

**To Prevent Adhesion:**
To prevent adhesion to the mold, use a GREASE-IT™ release agent. Porous surfaces, such as wood, plaster, foam, etc., must be sealed thoroughly before release is applied. Use multiple coats of a good quality coating, such as a high grade oil-based or urethane lacquer.

**To Promote Adhesion:**
The surface must be abraded, cleaned with a solvent and dried. Sandblasting and mechanical roughing are the preferred ways of abrading surfaces to be bonded. For added adhesion to metals, use Primer 200. For added adhesion to plastic, use Primer 810. Make sure all surfaces are clean, dry, and free from moisture.

## Mixing
Components may separate and should be mixed separately before each use. Mix, only when ready to use, by adding the curing agent to the resin portion and blending together thoroughly. Be sure to scrape and stir in all material sticking to the sides and bottom of the mixing container. Do not use paper containers or wooden mixing sticks. They may contain moisture. For best results, use plastic or coated containers, and metal or plastic sticks.

## Casting
Pour in a thin unbroken stream into the lowest point in the cavity or mold. This will help break up some of the air entrapped during mixing. For best results, Hapco recommends meter mix dispensing, vacuum degassing and/or pressure casting at 70-80 PSI.

## Postcure
Postcure Heat: 100-176°F (38-80°C) for a minimum of 6-12 hours.
Properties increase with heat acceleration. Izod impact and heat distortion properties increase with postcure heat. The lower the temperature, the longer the postcure (8-24 hours).

## Demold & Cure Times
Demold and final cure time can be accelerated with the addition of heat 100-176°F (38-80°C). To retain working life, heat the mold, not the material. Increasing the temperature of the mold to 80-100°F (26-38°C) will accelerate demold and cure times by up to 50%. For full cure polymers require at least 7-10 days. Please be aware that size and mass effect demold and cure times.

## Hardness
The hardness progresses more slowly in the longer working life systems. The hardness progression can be accelerated by using the faster version or by curing with mild heat. Hardness and cure progress will be retarded, slowed down, when the temperature falls below 70°F (21°C).

## Shrinkage
The values in the brochures are for comparative reference only, using ASTM testing procedures. Shrinkage or dimensional variation is largely influenced by mass (total volume and thickness), temperature (material and mold), and mold material. Geometry, part thickness, and total volume vary in each design, therefore, the customer is responsible to test and determine the shrinkage factor to be used.
### MATERIAL HANDLING & SAFETY NOTES

<table>
<thead>
<tr>
<th>SILICONE MOLDS</th>
<th>MACHINE MIXING AND DISPENSING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Silicone molds should be postcured at 120°F (48°C) overnight (8-24 hours). When using a tin-based silicone mold, make sure the mold is open when it is in the oven during postcure. Improperly cured silicone can cause a sticky surface on molded parts. This process also extends mold life.</td>
<td>Use Hapco’s RAPIDFIL™, MINIFIL™, and/or RAPIDSHOT™ dispensing machines for fast, reliable, and efficient mixing without the air entrapment, measuring, or mess associated with hand processing.</td>
</tr>
<tr>
<td><strong>CLEAN UP</strong></td>
<td><strong>SHELF LIFE</strong></td>
</tr>
<tr>
<td>Cured polymers are difficult to remove. It is best to clean tools and equipment immediately after use. For best results use Hapco’s A-TAK™.</td>
<td>The shelf life on Hapco products begins from the date of invoice for that product shipment. Hapco’s shelf life only pertains to containers that are unopened and in their original condition. Once the container is opened Hapco has no control or responsibility for the shelf life.</td>
</tr>
<tr>
<td><strong>STORAGE</strong></td>
<td><strong>RESEALING</strong></td>
</tr>
<tr>
<td>Store both components in an area with a temperature range of 68-90°F (20-32°C). Store in a dry place off of cement floors and on shelving if possible. Containers should be kept tightly closed.</td>
<td>Many polymers are moisture sensitive and should be resealed using one of the following methods: 1. Blanket with a dry gas like nitrogen or argon. 2. Use a hair dryer pointed into the opening of the container for 30 seconds.</td>
</tr>
<tr>
<td><strong>COLD TEMPERATURES</strong></td>
<td><strong>PRECAUTIONS</strong></td>
</tr>
<tr>
<td><strong>CAUTION:</strong> Part A may freeze or crystallize in cold temperatures. Part A may appear to be striated or solidify. This situation can easily be corrected. Place the cover on the Part A loosely (do not seal) and place in an oven set at 125-150°F (51-65°C) for 3-8 hours or 8-12 hours for drums. Re-seal, allow to cool, and then mix thoroughly. <strong>CAUTION:</strong> Part B may freeze or crystallize in cold temperatures. Part B may turn thicker, appear to be striated, thicken, or solidity. To prevent this see storage. This situation can be easily corrected. To reverse crystallization, loosen the cover on Part B and heat to 170-180°F (77-82°C) for 3–6 hours, drums, 6–12 hours. Allow to cool before using. If contents are pigmented, mix thoroughly.</td>
<td><strong>CAUTION:</strong> The Safety Data Sheets should be read thoroughly before using this product. Skin or eye contact with polymers should be avoided. The use of gloves, eye protection, and face masks are strongly recommended. All polymers, as a general practice, should be used in well-ventilated areas. Spot ventilation is most effective. Contaminated clothing should be removed immediately and the skin washed with soap and water or waterless skin cleaner. Should accidental eye contact occur, wash thoroughly with water and consult a physician.</td>
</tr>
</tbody>
</table>

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04/07/2020

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**PRODUCT DATA SHEET**

**SYMPOXY™ 1010-CA810**

**75 SHORE D EPOXY**

**MATERIAL PROCESSING**

**APPLICATIONS**

**USES**

**PRODUCT INFORMATION**

**SAFETY DATA SHEETS**

**PHYSICAL PROPERTIES**

**PACKAGING**

**HALFCO INCORPORATED**

Phone: 781-826-8801 Toll Free: 877 SAY HAPCO (729-4272)

353 Circuit Street, Hanover, Massachusetts 02339

info@hapcoincorporated.com

hapcoincorporated.com